



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D3368-1
Job Sheet 204818



Part No: D3368-1

Job Qty: 6 pcs

Part Name: Pedal Lock Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/20/19

Job Tracking No:

Due Date: 2/10/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV B IPP A 05.01.27 New issue KJ/JLM IPP Rev:B 08-07-17 add QC3 DD verified by:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	2/10/20	2/10/20	0.00	5.18	Bandsaw - 1		ALA 20/03/10
105	HAAS 4 Axis - B4B	6 pcs	2/10/20	2/10/20	1.00	5.18	HAAS - 1 - B4B		ALA 20/03/10
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	QC 2	6 pcs	2/10/20	2/10/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		ALA DAS 86 20/03/10
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S262421



Part: D3368-1

Job No: 204818

Serial No/Batch: S262421

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/10/20

Dart Aerospace Ltd.
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CANADA
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120 QC 8	6 pcs	2/10/20	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
130 Handfinish - 1-1 Chemical-B4B	6 pcs	2/10/20	0.00 0.60	QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS
				QC 8 - 52	52
				QC 8 - 23	9-89
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				Handfinish - 1 - 1 - B4B	BEB 20-04-02.
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 -	

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						B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
140	Powdercoat - 6 Fire Red - B4B	6	2/10/20	0.00	0.32	Powdercoat - 1 - B4B	
		pcs				Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
150	QC 3	6	2/10/20	0.00	0.00	QC 3 - 10	
		pcs				QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
160	Packaging 3-1 - Stock - B4B	6	2/10/20	0.00	0.00	Packaging 3 - 1 - B4B	
		pcs				Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	

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				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	6 pcs	2/10/20	0.00 0.00	QC 21 - SA - 21	APR 09 2020
				QC 21 - SA - 70	DAS 21
				QC 21 - SA - 53	9-20
Part Op 100 - (Bandsaw) Cut blanks as per folio Descriptions: 105 - (HAAS CNC Vertical Machine) 1-Machine D3368-1 as per Folio FA499 and Dwg D3368 Identify as D3368-1 2-Debur 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Chemical Conversion Coat per QSI005 4.1 140 - (Fire Red(Ref.4.3.5.10) per QSI005 4.3) ***Cover inside holes prior painting*** Heat oven at temperature for 45 minutes before putting part in oven by <u>11:00</u> Start Time: <u>0:30</u> Oven Temperature: <u>320</u> Finish Time: <u>11:00</u> 150 - QC3- Inspect Part Finish 160 - Identify as per dwg & Stock Location: _____ 170 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B2.000X02.000	6061-T6 Bar 2.00 X 2.00	5.4000 ft (.9 ea)	100-Bandsaw - 1	S250477 Gx	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B2.000X02.000	5	10	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order:	
Description: Pedal Lock Base		Part Number:	D3368-1
Inspection Dwg: D3368 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.249	(		H-G	3/006
7.250	+/-0.010	7.255	(		VERN	B18017739
0.107	+/-0.010	.106	(		"	"
1.800	+/-0.010	1.802			"	"
0.750	+/-0.010	.745			"	"
Ø1.031	+/-0.010	1.030			"	"
45°	+/-0.5°	45.2°			A-G	CNC-17
0.250	+/-0.010	.255			VERN	B18017739
2.00	+/-0.030	1.995			"	"
7°	+/-0.5°	7.4°			A-G	CNC-17
Ø0.230	+0.005/-0.000	.229			VERN	B18017739
1.250	+/-0.010	1.253			"	"
1.075	+/-0.010	1.077			"	"
R0.500	+/-0.010	R.5			RG	Ref.
0.375	+/-0.010	.372			VERN	B18017739
0.310	+/-0.010	.308			"	"
1.450	+/-0.005	1.451			"	"
0.375	+/-0.010	.372			"	"
5.125	+/-0.010	5.122			"	"

Measured by: ALK	Audited by: DAS 52	Prototype Approval:	N/A
Date: 20/03/10	Date: 20/03/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	
C	08.07.23	0.700 dimension removed	KJ/DD	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					